

Work Order ID 117760

Thursday, May 01, 2014 11:16:40 AM

117760

Page 1

Item ID: D3140-06

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Door

Start Date: 5/1/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/22/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: CLDate: 14/05/05

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3140

Rev F

100

0.00

100

Packaging

Memo

0.00

Packaging

Pick kit to ship to Delastek

CL 14/05/05

110

QC4- 100% Inspect kits for completeness

0.00

110

QC

Memo

0.00

Quality Control

DAS
06
SEP 16 2014 9:00

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 117760

Thursday, May 01, 2014 11:16:40 AM

117760

Page 2

Item ID: D3140-06 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Door
Start Date: 5/1/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 8/22/2014 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>24037</u>								
	Purchase Part Number: D3140-06								
	Supplier: Delastek								
	Ship kit and make as per dwg								
	Conformity Certificate and Process sheet required								
130	Receive & Inspect for Damage & Mat'l Certs	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC6- Inspect dimensions to drawing	0.00							
140									
QC	Memo	0.00							
Quality Control	Ensure a copy of certification of conformity and process sheet from Delastek is attached.								

Handwritten signatures and dates:
14/05/05 (1)
14/6/16 (1)
14/9/17

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </td> <td style="width: 33%;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </td> <td style="width: 33%;"> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </td> <td style="width: 33%;"> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </td> </tr> </table>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 117760

Thursday, May 01, 2014 11:16:40 AM

117760

Page 3

Item ID: D3140-06

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Door

Start Date: 5/1/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/22/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: CA

0.00

150

Packaging

Memo

0.00

Packaging

ST 14-09-07

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

14/9/1714-9-17

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____
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Picklist Print

Thursday, May 01, 2014 11:16:40 AM

Page 1

Work Order ID: 117760

117760

Parent Item: D3140-06

D3140-06

Parent Item Name: Door

Start Date: 5/1/2014

Required Date: 8/22/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.01.17 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3140-87		Manufactured	No			100	Each	8.0000	1	1			
D3140-87									**			CX14/05/05	
Doubler												1X 35/55	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST205				6					
				78719				6					
				ST241A				2					
				90778				2					
D3140-95		Manufactured	No			100	Each	13.0000	3	3			
D3140-95									**			CX14/05/05	
Doubler													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST027				13					
				52265				1					
				78722				12				3	
D3140-98		Manufactured	No			100	Each	3.0000	1	1			
D3140-98									**			CX14/05/05	
Doubler													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				CA				3					
				34376				3				1	
D3140-241		Manufactured	No			100	Each	3.0000	1	1			
D3140-241									**			CX14/05/05	
Doubler													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				CA				3					
				78723				3				1	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

Thursday, May 01, 2014 11:16:40 AM

Page 2

Work Order ID: 117760

117760

Parent Item: D3140-06

D3140-06

Parent Item Name: Door

Start Date: 5/1/2014

Required Date: 8/22/2014

Start Qty: 1.00

Required Qty: 1.00

D3140-303

Manufactured No

100

Each

2.0000

1

1

D3140-303

Doubler

02/14/05/05

Location

Loc Qty

Loc Code

ST241A

2

84215

2

1

D3140-06P

x1

117760 5/1/14 C

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </td> <td style="width: 33%;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </td> <td style="width: 33%;"> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </td> <td style="width: 33%;"> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </td> </tr> </table>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____
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DELASTEK Inc.
2699 5e Avenue
Local 14,
Grand-Mère, Québec G9T 2P7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice No.	58219
Customer No.	DART US

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200

Contact : Linda Lacelle

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200

Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
09-09-2014	01-05-2014	24599	Michael Gregoire	PO24037	Net 30 days USA
Ship Via	F.O.B.	Salesperson	GST/PST		
Fedex Freight LTL Collect	Point de départ	Melody Shapcott, ext. 235			
Order Qty	B.O. Qty	Current Ship	Item number	Description	
1	0	1	DKC135-0019	Line #2 D3140-06 Door Right Non Assy (Grosse) U of M: Chaque DWG D3140 REV. F Serial # Lot # 61668. 61668	
1	0	1	DKC135-0020	Line #4 D3140-08 Door Right Non Assy (Petite) U of M: Chaque DWG D3140 REV. F Serial # Lot # 61668. 61668	

DOCUMENT INCLUS



It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request

Accepted by:

Quality department

AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Jeudi, 2014-05-08 14:25:00
Utilisateur: marc dubé

Feuille de Procédé

8/9 juin

Client : DART US DART AEROSPACE
Numéro Job : 61668
Numéro : 3407
Numéro B.A. :
Cette fois : 2014-05-08 No. :
Prsht Rev. : NC
Prem. fois : - - Type :
Job précédente : 40734

Nom Dessin : DOOR KIT
Numéro Article : DKC135-0019-0020
Numéro Dessin : D3140
Projet Numéro : DK-359
Révision dessin : F
Matériel : Fibercote E-761
Date Dûe : 2014-05-15

Qté: 1 Ud UNITE

Écrit par :
Vérifié & Approuvé par :
Commentaires : N° de pièce Client: D3140-06/08

Process Sheet Rév.: 05 remplacer AAC0559 et
AAC0563 par AAC2032 et AAC1361 respectivement,
changé AC0883 et AC0884 par AAC1885 et AAC1887
respectivement à 2 endroits qui avait été oubliés

COPIE

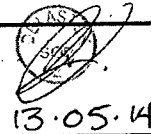
Produit additionnel

Numéro Job:



Séq.: Machine ou Description :

1.0 AAC0854 AAC2384 Frekote #700-NC # 710 NC
Comment Qty 0 030 UNITE(s)/Unit Total 0 030 UNITE(s)
Frekote #700-NC N° de Lot: 1-44859-1


13.05.14

2.0 PRÉPARATION Préparation du moule



Comment Setup: 0.00Hrs/ Run: 130.0000Min Total Run : 2.1667Hrs

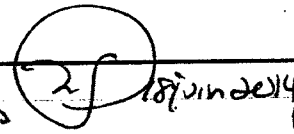
Faire la préparation du moule selon JF135-0002 et IG 0009.

Date: 14/05/14 Sceau:



3.0 AMB0211 Epoxy prepreg E-761 style 7781

Comment Qty.: 12.30 VERGE(s)/Unit Total: 12.30 VERGE(s) 21.5 verges
Epoxy prepreg E-761 style 7781 N° de Lot: 4575710AA


18 juin 2014


4.0 DECOUPE Découpe manuelle des pièces



Comment Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Découpe des tissus pré-impregné E-761 en paquet de 10.5 pi. (7 Paquet = 24.5 verges)

à la Gerber AMB0211

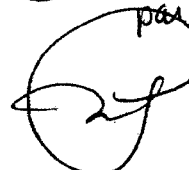
DKC135-0017/0018

Quantité: 1 Date: 26-06-14 Sceau:



Draper avec le # du pli
pas en dessous
















4450 N.S.


18 juin 2014


Date: Jeudi, 2014-05-08 14:25:01
















Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE	Nom Dessin: DOOR KIT	
Numéro Job: 61668	Numéro DKC135-0019/-0020	
Numéro Job: 		
# Séq.:	Machine ou Opération:	Description :
5.0	DRAPAGE	Dravage
  		
Comment Setup: 0.00Hrs/ Run: 12.0000Hrs Total Run : 12.0000Hrs		
Faire le dravage de 3 plis de tissus E-761 (4 Paquets) selon IF135-0002 + plan de découpe tissus		
Quantité: <u>1</u> Date: <u>7/07/14</u> Sceau:  		
6.0	AAC1885	Tissu à délaminer Release ply B
Comment Qty.: 4.37 VERGE(s)/Unit Total : 4.37 VERGE(s) Tissu à délaminer Release ply B # de Lot: <u>N/A</u>		
7.0	AAC1887	Wrightlon 5200 Bleu P3
Comment Qty.: 7.18 VERGE(s)/Unit Total : 7.18 VERGE(s) Wrightlon 5200 Bleu P3 # de Lot: <u>N/A</u>		
8.0	AC0885	Feutre de drainage N° Airweave N 10
Comment Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)		
9.0	AC0882	Sac à vide N° Strechlon 700
Comment Qty.: 7.770 VERGE(s)/Unit Total : 7.770 VERGE(s)		
10.0	AC0886	Rubar. à gonfler jaune #. TAT 200Y
Comment Qty.: 2.0000 ROULEAU(s)/Unit Total : 2.0000 ROULEAU(s)		
11.0	BAGGING	Faire le bagging sur la pièce
 		
Comment Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs		
Faire le bagging sur la pièce selon IF135-0002 et IG 0012.		
Quantité: <u>1</u> Date: <u>7/07/14</u> Sceau:  		
12.0	CUISSON	Cuisson de pièce
 		
Comment Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs		
Faire la cuisson de la pièce selon IF135-0002, IG 0012 et PTN #20. N°		
Cuisson: <u>8625</u>		
Quantité: <u>1</u> Date: <u>7-07-14</u> Sceau: 		
13.0	DÉMOULAGE	Démoulage de la pièce
 		
Comment Setup: 0.00Hrs/ Run: 240.0000Min Total Run : 4.0000Hrs		
Retirer le montage cuisson et faire les retouches de la pièce afin d'enlever les surplus de résine et les résidus de tissus à délaminer.		





Date: Jeudi, 2014-05-08 14:25:01
Utilisateur: marc dubé

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	DOOR KIT
Numéro Job:	61668	Numéro	DKC135-0019/-0020
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
Quantité:	1	Date:	7/08/14
		Sceau:	 
14.0	INSPECTION	Inspection générale	
			
Comment	Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs		
Inspection de la première coquille par le département de la qualité pour s'assurer qu'il n'y aie pas de réparation à faire avant la prochaine étape.			
Quantité:	1	Date:	7/08/14
		Sceau:	
15.0	AAC1618	Rohacell 71S 1"thick 49.2" x 98.4" plain	
Comment	Qty.: 2.000 FEUILLE(s)/Unit Total : 2.000 FEUILLE(s) Rohacell 71S 1"thick 49.2" x 98.4" plain N° de Lot: 1-45755-1		
16.0	DECOUPE	Découpe manuelle des pièces	
			
Comment	Setup: 0.00Hrs/ Run: 900.0000Min Total Run : 15.0000Hrs		
Faire la découpe des pièces de mousses structurales (Rohacell) sur la scie à ruban selon IF135-0002.			
Quantité:	1	Date:	18/06/14
		Sceau:	 
17.0	SÉCHAGE/ ANEAL	Séchage / Anealing	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
Faire le séchage du Rohacell selon IF135-0002 et les informations du manufacturier. N° Cuisson: 8568			
Quantité:	1	Date:	13/06/14
		Sceau:	 
18.0	AMB0442	Film adhesif EA9696 36" large x 0.06(psf)	
Comment	Qty.: 6.12 VERGE CAR(s)/Unit Total : 6.12 VERGE CAR(s) 5-75 verge 2 18 juin 2014 Film adhesif de EA9696 36" large x 0.06 (psf) N° de Lot: 		
19.0	AAC2032	Core splice adhesive NB-51/301	
Comment	Qty.: 5.0 PIED CARRE(s)/Unit Total : 5.0 PIED CARRE(s) Core splice adhesive NB-51/301 # de Lot: 4617910 AA		
20.0	AAC1361	Putty AD Tech P-17	
Comment	Qty.: 0.50 UNITE(s)/Unit Total : 0.50 UNITE(s) Putty AD Tech P-17 # de Lot: 1-45756-1		

















Date: Jeudi, 2014-05-08 14:25:01
Utilisateur: marc.dubé

Feuille de Procédé

Client: DART US DART AEROSPACE		Nom Dessin: DOOR KIT	
Numéro Job: 61668		Numéro DKC135-0019/-0020	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
21.0	AAC1646	N° D3140-10, Doubler	
Comment	Qty.: 1 UNITE(s)/Unit N° D3140-10, Doubler	Total : 1 UNITE(s) N° de Lot:	1-45913-13
22.0	AAC1631	N° D3140-87, Doubler	
Comment	Qty.: 1 UNITE(s)/Unit N° D3140-87, Doubler	Total : 1 UNITE(s) N° de Lot:	1-45913-1
23.0	AAC1633	N° D3140-92, Doubler	
Comment	Qty.: 1 UNITE(s)/Unit N° D3140-92, Doubler	Total : 1 UNITE(s) N° de Lot:	1-45913-14
24.0	AAC1634	N° D3140-95, Doubler	
Comment	Qty.: 3 UNITE(s)/Unit N° D3140-95, Doubler	Total : 3 UNITE(s) N° de Lot:	1-45913-2
25.0	AAC1636	N° D3140-98, Doubler	
Comment	Qty.: 1 UNITE(s)/Unit N° D3140-98, Doubler	Total : 1 UNITE(s) N° de Lot:	1-45913-17
26.0	AAC1637	N° D3140-99, Doubler	
Comment	Qty.: 1 UNITE(s)/Unit N° D3140-99, Doubler	Total : 1 UNITE(s) N° de Lot:	1-45913-9
27.0	AAC1638	N° D3140-101, Doubler	
Comment	Qty.: 2 UNITE(s)/Unit N° D3140-101, Doubler	Total : 2 UNITE(s) N° de Lot:	1-45913-10
28.0	AAC1640	N° D3140-104, Doubler	
Comment	Qty.: 1 UNITE(s)/Unit N° D3140-104, Doubler	Total : 1 UNITE(s) N° de Lot:	1-45913-15
29.0	AAC1642	N° D3140-106, Doubler	
Comment	Qty.: 1 UNITE(s)/Unit N° D3140-106, Doubler	Total : 1 UNITE(s) N° de Lot:	1-45913-16
30.0	AAC1643	N° D3140-241, Doubler	
Comment	Qty.: 1 UNITE(s)/Unit N° D3140-241, Doubler	Total : 1 UNITE(s) N° de Lot:	1-45913-4
31.0	AAC1645	N° D3140-303, Doubler	
Comment	Qty.: 2 UNITE(s)/Unit N° D3140-303, Doubler	Total : 2 UNITE(s) N° de Lot:	1-45913-6
32.0	NETTOYAGE	Nettoyage des pièces	
			
Comment	Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs		
Faire le nettoyage des doublers selon IG 0063.			
Quantité:	1	Date:	15/08/14
		Niveau:	

Date: Jeudi, 2014-05-08 14:25:01
Utilisateur: marc dubé












Feuille de Procédé

Client: DART US DART AEROSPACE		Nom Dessin: DOOR KIT	
Numéro Job: 61668		Numéro: DKC135-0019/-0020	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
33.0	ASSEMBLAGE	Assemblage mécanique	
			
Comment Setup: 960.0Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Mise en place des doublers et des pièces de la mousse structurale selon IF135-0002.			
Quantité: <u>1</u> Date: <u>19-08-14</u> Sceau:  			
34.0	AAC1885	Tissu à délaminer Release ply B	
Comment Qty.: 4.37 VERGE(s)/Unit Total : 4.37 VERGE(s)			
35.0	AAC1887	Wrightlon 5200 Bleu P3	
Comment Qty.: 7.18 VERGE(s)/Unit Total : 7.18 VERGE(s)			
36.0	AC0885	Feutre de drainage N° Airweave N 10	
Comment Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)			
37.0	AC0882	Sac à vide N° Strechlon 700	
Comment Qty.: 7.770 VERGE(s)/Unit Total : 7.770 VERGE(s)			
38.0	AC0886	Ruban à gommer jaune #: T/AT-200Y	
Comment Qty.: 2.0000 ROULEAU(s)/Unit Total : 2.0000 ROULEAU(s)			
39.0	BAGGING	Faire le bagging sur la pièce	
			
Comment Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs			
Faire le montage cuisson selon IF135-0002 et IG 0012.			
Quantité: <u>1</u> Date: <u>19-08-14</u> Sceau:  			
40.0	CUISSON	Cuisson de pièce	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs			
Faire la cuisson de la pièce selon IF135-0002, IG 0012 et PTN #21. N°			
Cuisson: <u>8720</u>			
Quantité: <u>1</u> Date: <u>19-08-14</u> Sceau: 			
41.0	DÉMOULAGE	Démoulage de la pièce	
			
Comment Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs			
Retirer le montage cuisson de sur la pièce et enlever les résidus de ruban adhésif en teflon et les barres d'aluminium. Garder seulement la barre qui sépare les deux pièces.			
Quantité: <u>1</u> Date: <u>20/08/14</u> Sceau:  			

Date: Jeudi, 2014-05-08 14:25:01

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE	Nom Dessin: DOOR KIT	
Numéro Job: 61668	Numéro DKC135-0019/-0020	
Numéro Job: 		
# Séq.:	Machine ou Opération:	Description :
42.0	DECOUPE	Découpe manuelle des pièces
 		
Comment Setup: 0.00Hrs/ Run: 900.0000Min Total Run : 15.0000Hrs		
Usinage des mousses structurales selon IF135-0002 et installer les doublers		
Quantité: 1	Date: 25/08/14	Sceau:  
43.0	INSPECTION	Inspection générale
 		
Comment Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs		
Faire la vérification de l'usinage intérieur pour s'assurer que tout soit conforme au dessin avant la prochaine étape.		
Quantité: 1	Date: 25/08/14	Sceau: 
44.0	AMB0211	Epoxy prepreg E-761 style 7781
Comment Qty.: 12.30 VERGE(s)/Unit Total: 12.30 VERGE(s)		
Epoxy prepreg E-761 style 7781 N° de Lot: <i>route à l'étape 5.0</i>		
45.0	DRAPAGE	Drapage
 		
Comment Setup: 0.00Hrs/ Run: 12.0000Hrs Total Run : 12.0000Hrs		
Drapage de la coquille intérieure selon IF135-0002 + <i>plan de découpe et drapage</i>		
Quantité: 1	Date: 27-08-14	Sceau: 
46.0	AAC1885	Tissu à délaminer Release ply B
Comment Qty.: 4.37 VERGE(s)/Unit Total: 4.37 VERGE(s)		
47.0	AAC1887	Wrightlon 5200 Bleu P3
Comment Qty.: 7.18 VERGE(s)/Unit Total: 7.18 VERGE(s)		
48.0	AC0885	Feutre de drainage N° Airweave N 10
Comment Qty.: 6.00 VERGE(s)/Unit Total: 6.00 VERGE(s)		
49.0	AC0882	Sac à vide N° Strechlon 700
Comment Qty.: 7.770 VERGE(s)/Unit Total: 7.770 VERGE(s)		
50.0	AC0886	Ruban à gommer jaune #: T/AT-200Y
Comment Qty.: 2.0000 ROULEAU(s)/Unit Total: 2.0000 ROULEAU(s)		

Date: Jeudi, 2014-05-08 14:25:01
Utilisateur: marc.dubé

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 61668

Nom Dessin: DOOR KIT
Numéro DKC135-0019/-0020

Numéro Job:







Séq.: Machine ou Opération: Description :

51.0 BAGGING Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs

Faire le montage cuisson selon IF135-0002 et IG 0012.


Quantité: 1 Date: 27-08-14 Sceau:    

52.0 CUISSON Cuisson de pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

Faire la cuisson de la pièce selon IF135-0002, IG 0012 et PTN #20. N°

Cuisson: 8748
Quantité: 1 Date: 27-08-14 Sceau: 



53.0 DÉMOULAGE Démoulage de la pièce



Comment Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Retirer le montage cuisson et faire des retouches sur la pièce afin d'enlever les surplus de résine et les résidus de tissus à délaminer.

Retirer la pièce du moule.


Quantité: 1 Date: 29/08/14 Sceau:  

54.0 INSPECTION Inspection générale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'inspection par le département de la qualité "Tap test et inspection dimensionnelle".



Quantité: 1 Date: 02/09/14 Sceau: 

55.0 TRIMAGE Trimage



Comment Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs

Faire le trimage de finition de la pièce selon IF135-0003.

Quantité: 1 Date: 02-09-14 Sceau:  

Date: Jeudi, 2014-05-08 14:25:01

Utilisateur: marc.dubé

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 61668

Nom Dessin: DOOR KIT
Numéro DKC135-0019/-0020

Numéro Job:



Séq.: Machine ou Opération: Description :

56.0 AAC1021 Dupont Primer N° 7704S

Comment Qty.: 0.5000 UNITE(s)/Unit Total: 0.5000 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 4748930411

57.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Comment Qty.: 0.0283 UNITE(s)/Unit Total: 0.0283 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1

58.0 PRIMER Application primer



Comment Setup: 0.00Hrs/ Run: 60.0000Min Total Run: 1.0000Hrs

Faire l'application du primer selon IG 0008.

Quantité: 1 Date: 02-09-14 Sceau: 4349 N° fiche
Mélange: 6648

59.0 SABLAGE Sablage



Comment Setup: 0.00Hrs/ Run: 240.0000Min Total Run: 4.0000Hrs

Faire le sablage du primer selon IF135-0003.

Quantité: 1 Date: 03-09-14 Sceau: 73

60.0 PRIMER Application primer



Comment Setup: 0.00Hrs/ Run: 60.0000Min Total Run: 1.0000Hrs

Faire l'application du primer selon IG 0008.

Quantité: 1 Date: 04-09-14 Sceau: 4349 N° fiche
Mélange: 6633

OK 5 sept 2014
IV

61.0 IDENTIFICATION Identification des pièces



Comment Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs

Faire l'identification des pièces sur l'aluminium peinturé dans le dégagement des mécanismes de porte selon IG 0055.

N° de pièce Grosse porte: D3140-06

N° de pièce Petite porte: D3140-08

N° de Job (sur les 2 pièces): 61668

Date de fabrication (sur les 2 pièces): 09-09-14

Sceau d'inspection.

Date: Jeudi, 2014-05-08 14:25:01

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: DOOR KIT

Numéro Job: 61668

Numéro DKC135-0019/-0020

Numéro Job:



Séq.:

Machine ou Opération:

9-9-14

44518m

Description :

Quantité: ~~1~~

Date: ~~5-5-14~~

Sceau: ~~CA-3~~

62.0

INSPÉC FINAL

Inspection finale



Comment Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire l'inspection finale des pièces par le département de la qualité selon le dessin D3140.

Quantité: 1

Date: 09/09/14

Sceau:

63.0

EMBAL / ENTREPO

Emballage & Entreposage



Comment Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Emballer et entreposer selon IG 0057.


Quantité: 1

Date: 9-9-14

Sceau: 44518m

N° Bon de travail: 61668

N° pièce: DOOR KIT
DKC135-0019 / 0020

Article	Description	N° lot	Date de sortie	Heure de sortie	Temps restant Temp. Ambiante	Date expiration	Sceau employé
AAC1471	COPPER MESH						
AAC1541	CORE SPLICE						
AMB0211	EPOXY PREPREG	457570AA ^(R-1)	25-06-14	14:30	720 H	23-12-14	
AMB0327	EPOXY PREPREG						
AMB0326	CARBONE						
AMB0442	FILM ADHÉSIF	1-45751-1	22-06-14	17:00	1440.	22-05-15	